



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

C20-405
Job Sheet 182163



Part No: C20-405

Job Qty: 3 ea

Part Name: Stationary Keeper



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/20/18

Job Tracking No:

Due Date: 8/24/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C20-405 Rev. 3 IPP Rev. A 18.04.24 new issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea	8/24/18	8/24/18	0.00	0.00	Start Up Machining-3		J.C.L.
110	Mori Seiki	3 pcs	8/24/18	8/24/18	0.00	1.50	MORI NV5000-2		J.C.L.
120	QC	3 pcs	8/24/18	8/24/18	0.00	0.00	QC2 Machining-4		J.C.L. 18-08-23
130	QC	3 pcs	8/24/18	8/24/18	0.00	0.00	QC8 Machining-4		ML 18/08/24
135	Outsource	3 pcs	8/24/18	8/24/18	0.00	0.00	Outsource1		CT 18-8-24
140	Outsource	3 pcs	8/24/18	8/24/18	0.00	0.00	Outsource15		CT 18-8-24
150	Packaging	3 pcs	8/24/18	8/24/18	0.00	0.00	Packaging2		ML 18-8-24
160	QC	3 pcs	8/24/18	8/24/18	0.00	0.00	QC6		ML 18-8-24
210	Packaging	3 pcs	8/24/18	8/24/18	0.00	0.00	Packaging3-1		ML 18-8-24
220	QC21-SA	3 Ea	8/24/18	8/24/18	0.00	0.00	QC21		ML 18-8-24

Part Op 110 - ***Cut blanks to 6.25*** 1-Machine as per folio FC 312 FOLIO REV: N/A DWG REV: 3

Descriptions: 3 2-Deburr

120 - Engrave BATCH number using MARKTRONIC engraver as per DWG.

135 - 1--Issue P/O to Metcore; P/O 040838 RC 46-50 2-Bead blast 3- Certificate of Conformity is required

NOTE DROP SHIP TO FINISHER Metcore to ship directly to Groupe Altech***

140 - -Issue P/O to Groupe Altech: P/O 040838 Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004-.0006 -Bake after plating -Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-S-2.750X5.125	4140 Steel Sheet 2.750 X 5.125	1.5600 ft (.52 ea)	90-Start up Operation	5069 833

Job Allocations

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

onent Part
40-S-2.750X5.125

Required
2

Inventory
4

Allocated
0

Part Specifications

Specifications could not be found.

Plex 8/20/18 10:26 AM Dart.lajeunesse.marie



Container No: S104352



Part: C20-405

Job No: 182163

Serial No/Batch: S104352

Revision: 3

Inspector:

Exp Date:

Instructions:

Date: 08/22/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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WORK ORDER NON-CONFORMANCE / UPDATE



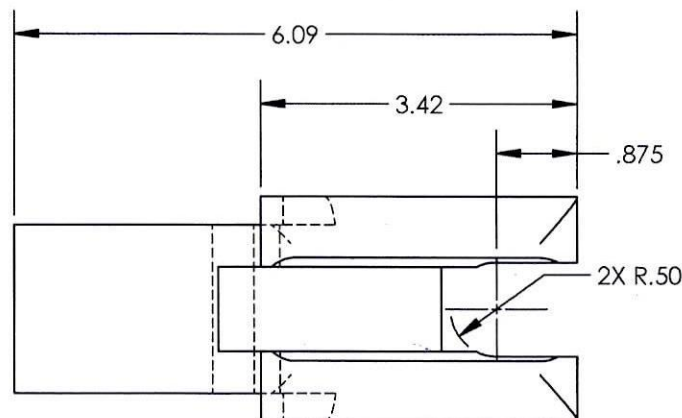
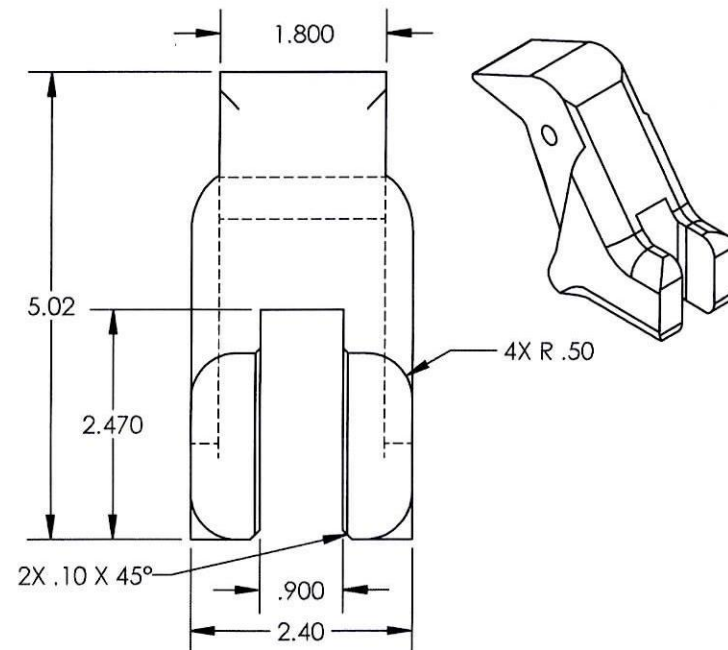
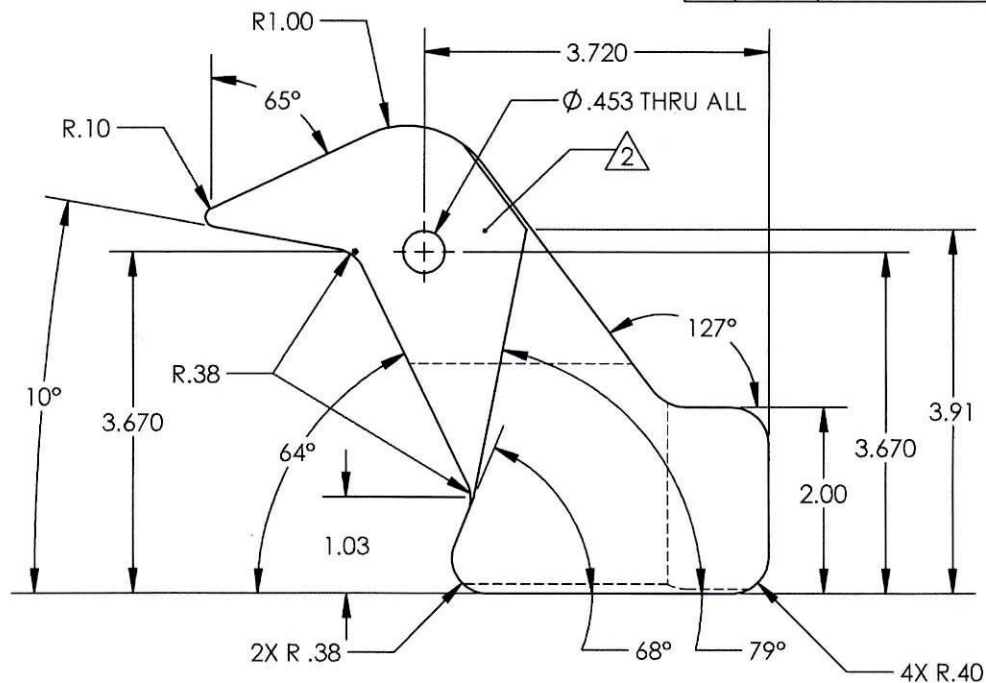
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Work Order update only ☐

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
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				Lead hand / Supervisor Approval Verification	
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OTHER : _____					

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
1		RELEASED FOR PRODUCTION.	5/25/2016
2	16-0121	CH'D DIM WAS .500 IS .875, WAS 2X R.75 IS 2X R.50, WAS 1.99 IS 2.00, WAS 3.667 IS 3.670, WAS Ø.765 IS Ø.680.	8/16/2016
3	17-0030	CH'D DIM WAS Ø.680 IS Ø.453 THRU ALL, WAS .800 IS .900; ADDED DIM 2X .10 X 45°.	1/27/2017



NOTES:

1. NICKEL PLATE .0004 - .0006, BAKE AFTER PLATING.

2. MACHINE ENGRAVE BATCH NUMBER.

DART AEROSPACE	
TITLE STATIONARY KEEPER	
DWG NO. C20-405	REV 3
MAT'L 4140/4142 HEAT TREAT RC 46-50 FINISH SEE NOTE 1 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: WALLRICH CHECKED: CLOUGH OPPS APPR: ANDERSON QA APPR: LINDSAY APPROVED: GILBERT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
USED ON MODEL	
SCALE 1:2	DATE 6/5/2015
SHEET 1 OF 1	

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS
			C20-405	1	STATIONARY KEEPER	4140/4142	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040872**

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040872
PO Date: 8/28/18
Due Date: 8/30/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	182163	C20-405	Stationary Keeper -Issue P/O to Groupe Altech: P/O _____ -Nickel plate, QQ-N-290, Class 2, Grade E or F -Nickel Plate .0004- .0006 -Bake after plating -Certificate of Conformity is required	Firmed	-	8/30/18	3 pcs	0 pcs	3 pcs	\$63.333333/pcs	\$190.00

3 X

AUG 31 2018

[Signature]

DAE
38
9-89

Grand Total: \$190.00

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

CC

Plex 8/29/18 1:25 PM dart.tsimiklis.chrisoula



Certificat de Conformité / Certificate of Compliance

(012199-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
Tel: 514-335-3666 Fax: 514-335-3868
www.groupaltech.com

Bon de Livraison / Packing Slip

012199 - 1

Livré à / Ship to

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD

1270 ABERDEEN STREET

HAWKESBURY, ON, K6A1K7

CANADA

BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.					
30-Aug-2018		Aman		040872					
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap	À venir/ Back Order	
1	C20-405 ✓ Rev.	C20-405 ✓ 01 - E-NIC STEEL 200 [E-NICKEL STEEL 200] QQ-N-290 CLASS 2 GRADE E OR F NICKEL PLATE 0.0004-0.0006 THICK BAKE AFTER PLATING	E-NICKEL-500 CH	3 ✓	3	0	0	0	DAS 38 9-89

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual ThicknessInspecteur Qualité
Quality InspectorRéçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
Our financial and legal responsibility will not be higher than the amount of invoice.